

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017973**Date Inspected:** 13-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG COMPONENT				

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (UT) for Segment 12BW

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as OBG segment 12BW weld joints.

The welds designation reviewed are as follows:

SEG3005K-018,031,059,070,073,089
SEG3005M-018,031,046,059,070,073,089
SEG3005B-001
SEG3005D-001,007
SEG3005H-001
SEG3005F-003
DP3056-001-011~019

During the Quality Assurance Ultrasonic Testing (UT) review of welds located on Orthotropic Box Girder (OBG) segment 12BW, this Quality Assurance Inspector (QA) discovered the following issues One (1) longitudinal linear

WELDING INSPECTION REPORT

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Class “A” rejectable indication measuring approximately 15mm in length. The indication dbb rating is a +5. Material thickness is 18mm. The depth of the indication from scanning side is approximately 23mm. The weld is identified as SEG3005K-046. The weld is Complete Joint Penetration (CJP) “T” joint. The “T” joint joining between Bottom Plate BP3022A to LD3021A. The weld is designated as seismic Performance Critical Material (SPCM). The indication is in base metal and 5mm inside from weld, clearly marked near the weld. Segment 12BW is located near trial assembly yard. The Notice of Witness Inspection (NWIT) No. is 006972. The indication is located within an area previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC’s QC personnel are required to perform hundred (100%) percent UT inspection of this weld.

This QA inspector did not generate any incident report on this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
